

shp 03/04

Dart Aerospace Ltd.

Date: Wednesday, 3/26/2008 9:54:12 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MAINTENANCE STEP, LH
Job Number : 38180	
Estimate Number : 11283	
P.O. Number :	Part Number : D3436043
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3436 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 35086	Material :
Written By :	Due Date : 4/2/2008 Qty: <b>2</b> Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est .A 05.05.11 New Issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34361	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

1	D3436-1	Clamp	<u>338193</u>
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JD 08.03.31

2

2.0	D34363	Left Step
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LH Step

Pick:

Qty Part Number Description Batch

1	D3436-3	LH Step	<u>338194</u>
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JD 08.03.31

2

3.0	D34365	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

4	D3436-5	Bushing	<u>323357</u>
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JD 08.03.31

2

4.0	D34367	Cap
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty Part Number Description Batch

1	D3436-7	Cap	<u>338196</u>
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JD 08.03.31

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:13 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, LH

Job Number: 38180

Part Number: D3436043

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev:

A  
Qty Part Number Description Batch  
A/R/N/A 4130 Welding Rod M100075

Weld left step D3436-7 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch  
A/R/N/A 4130 Welding Rod M100075

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty Part Number Description Batch  
A/R/N/A 4130 Welding Rod M100075

PH 08.03.31 2  
PH 08.03.31 2  
PH 08.03.31 2

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

Slit part D3436-041 on bandsaw as per Dwg D3436

PH 08.04.1 2

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

18/04/01 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18/04/01 (2)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Deburr

SB 08/04/01 (2)

10.0

POWDER COATING

POWDER COATING



M 107550



(2X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

M-1 08/04/01

FL 08/04/02 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:13 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, LH

Job Number: 38180

Part Number: D3436043

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ECB 08/04/02 (2)*

12.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty	Part Number	Description
2	D3436-9	Pad
A/R	N/A	Contact Cement

Batch:

*B338191 (1) B35490 (3\*)  
M102565*

*DCB 08/04/02 (2)*

*ECB 08/04/02*

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*I 08/04/02 (2) (CH)*

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 455

*AS 08/04/02 (2)*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/02 (2)*

Job Completion



*u 08-04-02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

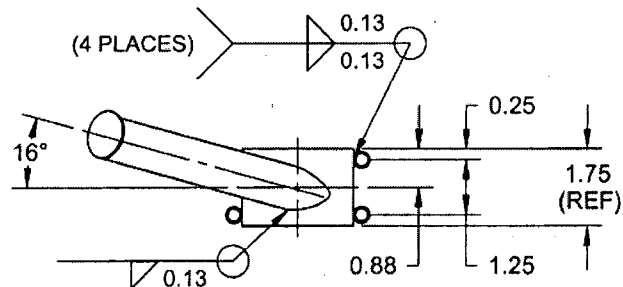
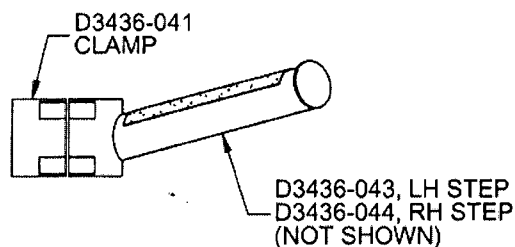
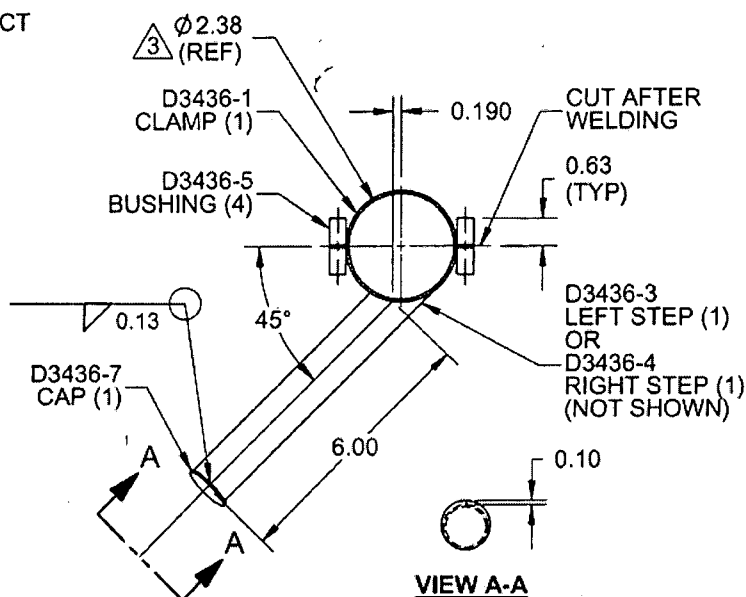
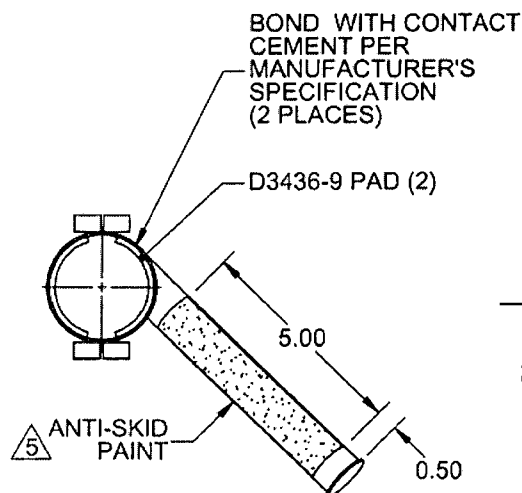
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:4
A	05.04.28	NEW ISSUE	

**NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.05.27 [Signature]

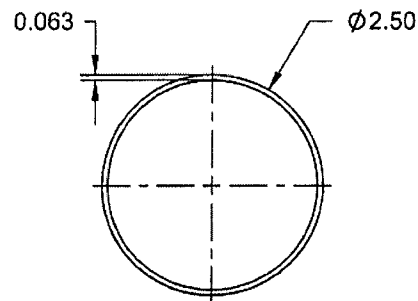
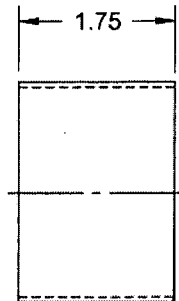
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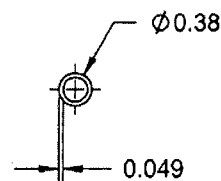
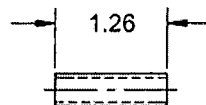


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DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:2



#### **D3436-1 CLAMP**

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



#### **D3436-5 BUSHING**

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

**RELEASED**

05-05-27 *[Signature]*

#### **D3436-1/ -5, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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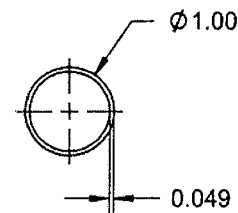
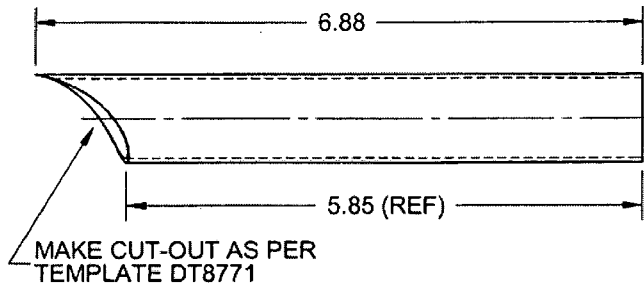
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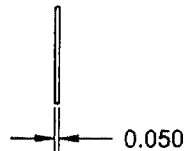
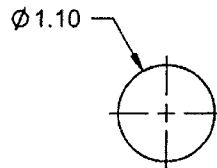
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DATE <b>05.04.28</b>		TITLE <b>MAINTENANCE STEP</b>	SCALE 1:2



#### **D3436-3 LEFT STEP**

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



#### **D3436-7 CAP**

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

**RELEASED**

05-05-27 *[Signature]*

#### **D3436-3/-7, GENERAL NOTES:**

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

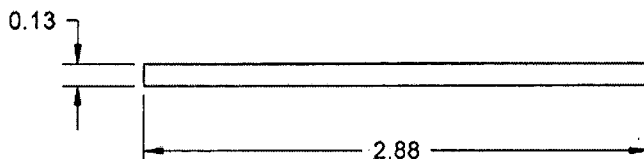
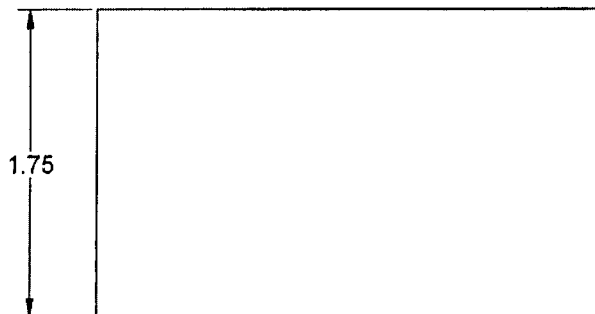
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DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



RELEASED  
05.05.27 *[Signature]*

**D3436-9 PAD**

**NOTES:**

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK  
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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